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D205-634-141
Job Sheet 176710



Part No: D205-634-141

Job Qty: 1 ea

Part Name: Replacement Skidtube with Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/27/18

Job Tracking No:

Due Date: 5/30/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: D205-634 REV.I/ D2580 REV.H IPP RevA 11.09.14 new issue EC verified by:DD IPP REV:B 12.01.23 AS PER ECN11-684 DD VERF:EC IPP REV:C 13.03.21 AS PER ECN13-544 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/30/18	0.00	0.00	Start Up Skidtubes-1		MGU
110	Skidtubes	1 pcs		5/30/18	0.00	0.65	Skidtubes-2		MGU
120	CNC Bend Skidtubes	1 pcs		5/30/18	0.52	0.65	CNC Bend Skidtube		J.Y
130	Skidtubes	1 pcs		5/30/18	0.00	0.65	Skidtubes-2		J.Y
140	QC	1 pcs		5/30/18	0.00	0.00	QC5		J.Y
150	Skidtubes	1 pcs		5/30/18	0.00	0.65	*Skidtubes-2		J.Y
160	QC	1 pcs		5/30/18	0.00	0.00	QC10		38 DAS
170	QC	1 pcs		5/30/18	0.00	0.00	QC5		9-89 38
180	HandFinish	1 pcs		5/30/18	0.00	0.04	HandFinish2		SA 18-05-23
190	Powdercoat	1 pcs		5/30/18	0.00	0.25	Powdercoat1		BR 18-5-25
200	QC	1 pcs		5/30/18	0.00	0.00	QC3		BEP 18-06-01
210	HandFinish	1 pcs		5/30/18	0.00	0.83	HandFinish4		JUL 18-6-12
220	QC	1 pcs		5/30/18	0.00	0.00	QC5		38
225	DC	1 pcs		5/30/18	0.00	0.00	DC		9-89
230	Packaging	1 pcs		5/30/18	0.00	0.00	Packaging3-1		JUL 13 2018
240	QC21-FG	1 Ea		5/30/18	0.00	0.00	QC21		18.07.13

Part Op 110 - 1- PICK D2580-1 2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021, DRILL 3.630" HOLES

Descriptions: USING DT8462 (83.94" FROM AFT OF D2580-1 REF. ONLY)

120 - 1-Bend as per program D2580.C on CNC Bender and Folio FT 16

130 - 1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required. 2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832 REF) as per dwg D2580 sheet 7. 3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63 REF) as per dwg D2580 sheet 7. 4-Drill pilot holes for aft cap using DT8215, Open to finished size.

150 - 1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R Aluminum Rod 038611 2-Touch up alodine on run on wearplate holes prior to swaging 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg 4-DRILL TOWING HOLE USING DT8091 5-DEBURR

180 - And realodine tube as per QSI 005

190 - START TIME: 8:25 O.V.T. 300° FINISH: 9:00 M138739.

EXP 18/12

210 - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 115787 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594 3- Install aft cap as per dwg 4- Wing walk as per dwg Batch# 1138761

220 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

225 - Photocopy D205-634 bluefile & type labels per PPP D205-634-141 CHG004

230 - Identify and pack for shipping as per PPPD205-634-141 Location : FG084

003816

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 Ea (1 ea)	90-Start up Operation	S06857E
D2576-3	Step (Machining Detail)	1 Ea (1 ea)	150-Skidtubes	S069014
D4202-1	Spacer	24 Ea (24 ea)	150-Skidtubes	S054571
AN3-5A	Bolt	2 Ea (2 ea)	210-HandFinish	S041106-1
AN4-45A	Bolt	8 Ea (8 ea)	210-HandFinish	S056004
D2570	Bushing	16 Ea (16 ea)	210-HandFinish	15xS068647/1xS068688
D2594-1	Plug	8 Ea (8 ea)	210-HandFinish	S059024
D2594-3	O-Ring	8 Ea (8 ea)	210-HandFinish	S049975
D2855	Cap	1 Ea (1 ea)	210-HandFinish	F151613
D4406-041	Fwd Wearplate Assembly	1 Ea (1 ea)	210-HandFinish	S068253
D4406-043	Aft Wearplate Assembly	1 Ea (1 ea)	210-HandFinish	S073948
MS21042-4	Nut	8 Ea (8 ea)	210-HandFinish	S058763
NAS1149D0332J	Washer	2 Ea (2 ea)	210-HandFinish	S026606-1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2580-1	1	2	0
150-Skidtubes	D2576-3	1	5	0
	D4202-1	24	648	0
210-HandFinish	AN3-5A	2	371	0
	AN4-45A	8	58	0
	D2570	16	298	0
	D2594-1	8	640	0
	D2594-3	8	909	0
	D2855	1	106	0
	D4406-041	1	2	0
	D4406-043	1	3	0
	MS21042-4	8	131	0
	NAS1149D0332J	2	2,465	0

Part Specifications

Specifications could not be found.

Plex 4/27/18 2:16 PM dart.lacelle.linda

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Container No: S069053



Part: D205-634-141

Job No: 176710

Serial No/Batch: S069053

Revision: H/I

Inspector:

Date: 05/07/18